

Date: Monday, 21/07/2008 10:53:35 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: END FITTING ASS'Y LH			
Job Number	: 40685						
Estimate Number	: 13344						
P.O. Number	:			Part Number	: D3763043		
This Issue	: 21/07/2008	S.O. No. :		Drawing Number	: D3763 REV B		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: / /		Type	: LARGE FAB ASSY			
Previous Run	: 39484			Drawing Revision	: B		
Written By				Material	:		
Checked & Approved By	: <u>Julie Lecocq</u>			Due Date	: 01/08/2008		
Comment	: Est Rev:A 08-05-20 new issue DD verified by:ec			Qty:	4		
	: Est Rev:B 08-07-18 revB as per dwg DD verified by:EC			Um:	Each		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PACKAGING 1	PACKAGING RESOURCE #1	
<b>Comment:</b> PACKAGING RESOURCE #1 Pick Packing Kit			
2.0 D37631 End Fitting			
<b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) End Fitting batch: <u>40703</u>			
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Tube batch: <u>40705</u>			
4.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1			
<b>Comment:</b> LARGE FABRICATION RESOURCE 1 1-make a 0.063" chamfer on D3763-1 fitting before ass'y 2-assemble and tack weld as per dwg D3763 using locating pin DT9014 *****look at dwg before assembling parts (LH)***** *****remove pin before welding*****			
3-weld as per dwg D3763 QSI004 Alum. rod Batch: <u>M108436</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

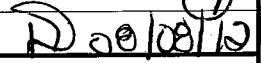
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: END FITTING ASS'Y LH
Job Number: 40685		Part Number: D3763043
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
5.0	QC9	VISUAL WELDING INSPECTION 
Comment: VISUAL WELDING INSPECTION		DD 08-08-08 (4) 
6.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		S08/08/08 (4) 
7.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify with Dart part # using a fine point permanent marker and Stock Location: 117 8/8/11		48  S6 
8.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		DD 08/08/10  MF 08-08-11
Job Completion 		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
8/08/11	#6.1	<del>6.8</del> Add chemical coat as per QSZ005	RD	08/08/11	44		S 08/08/11
	#6.2	QC3. inspect chemical coat. Permit Change * Copy to David D. 8/08/11		08/08/11	44	108/08/11	

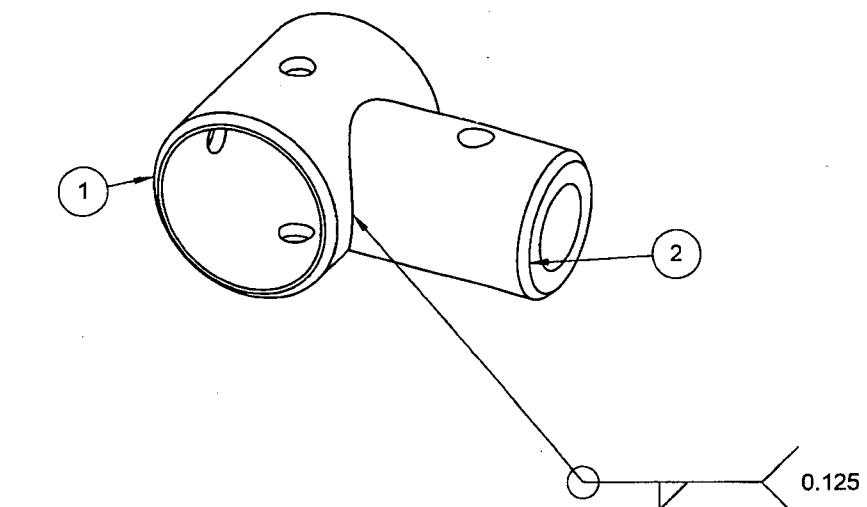
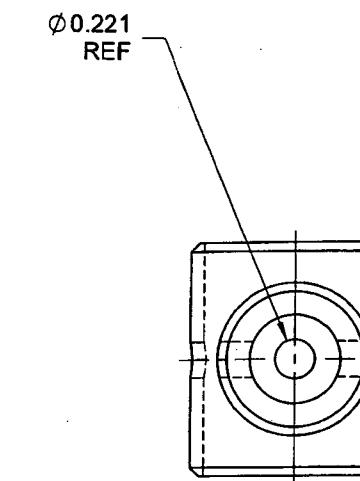
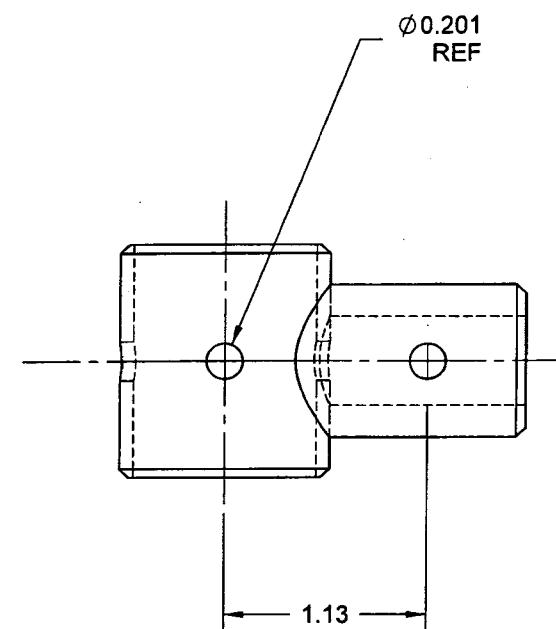
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3763-3	TUBE	1
2	D3763-1	FITTING	1

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WITHOUT NOTICE  
WORK ORDER  
NO. 40085

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08.07.10 MFD

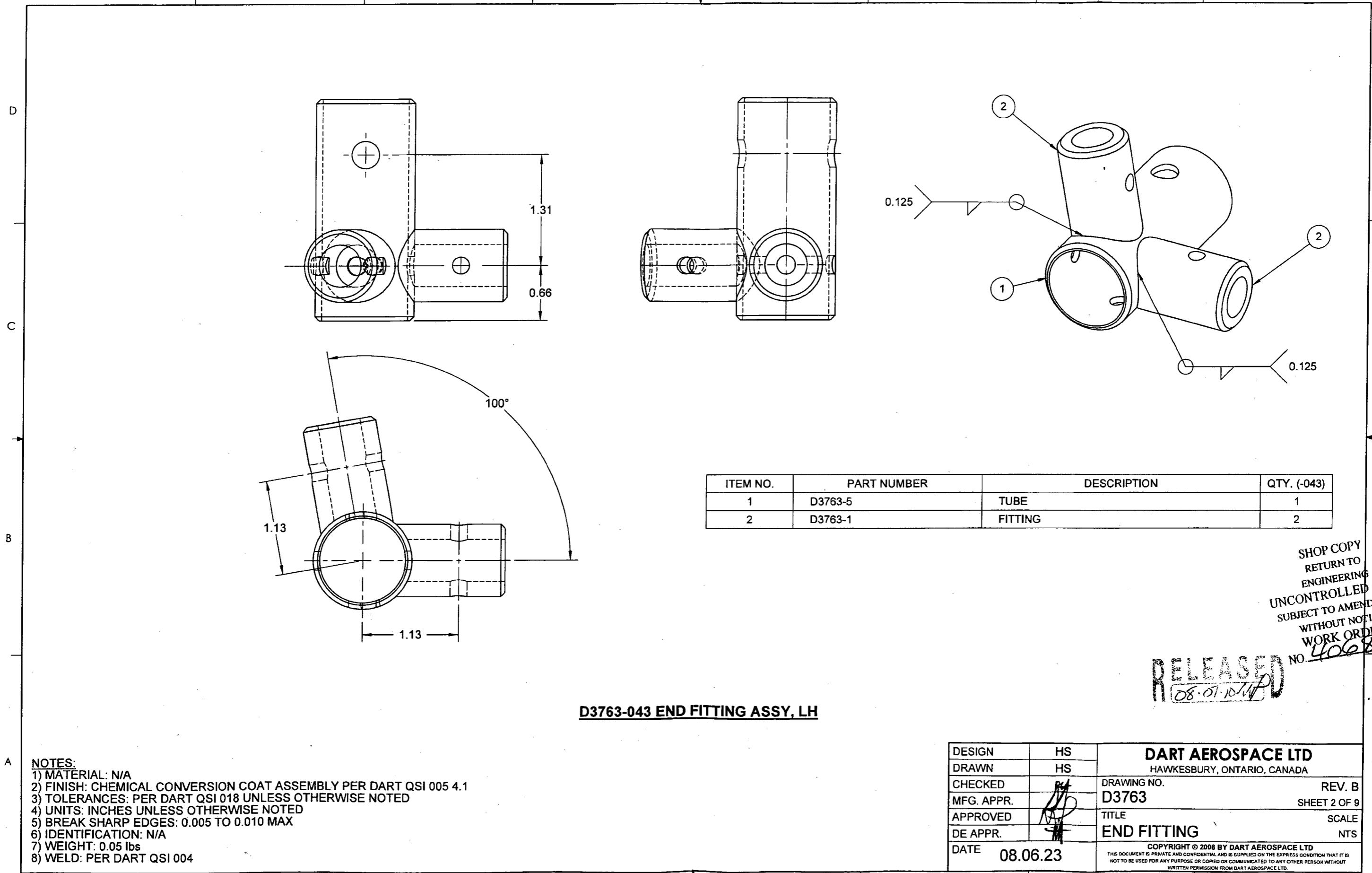
**D3763-041 END FITTING ASSY**

**NOTES:**

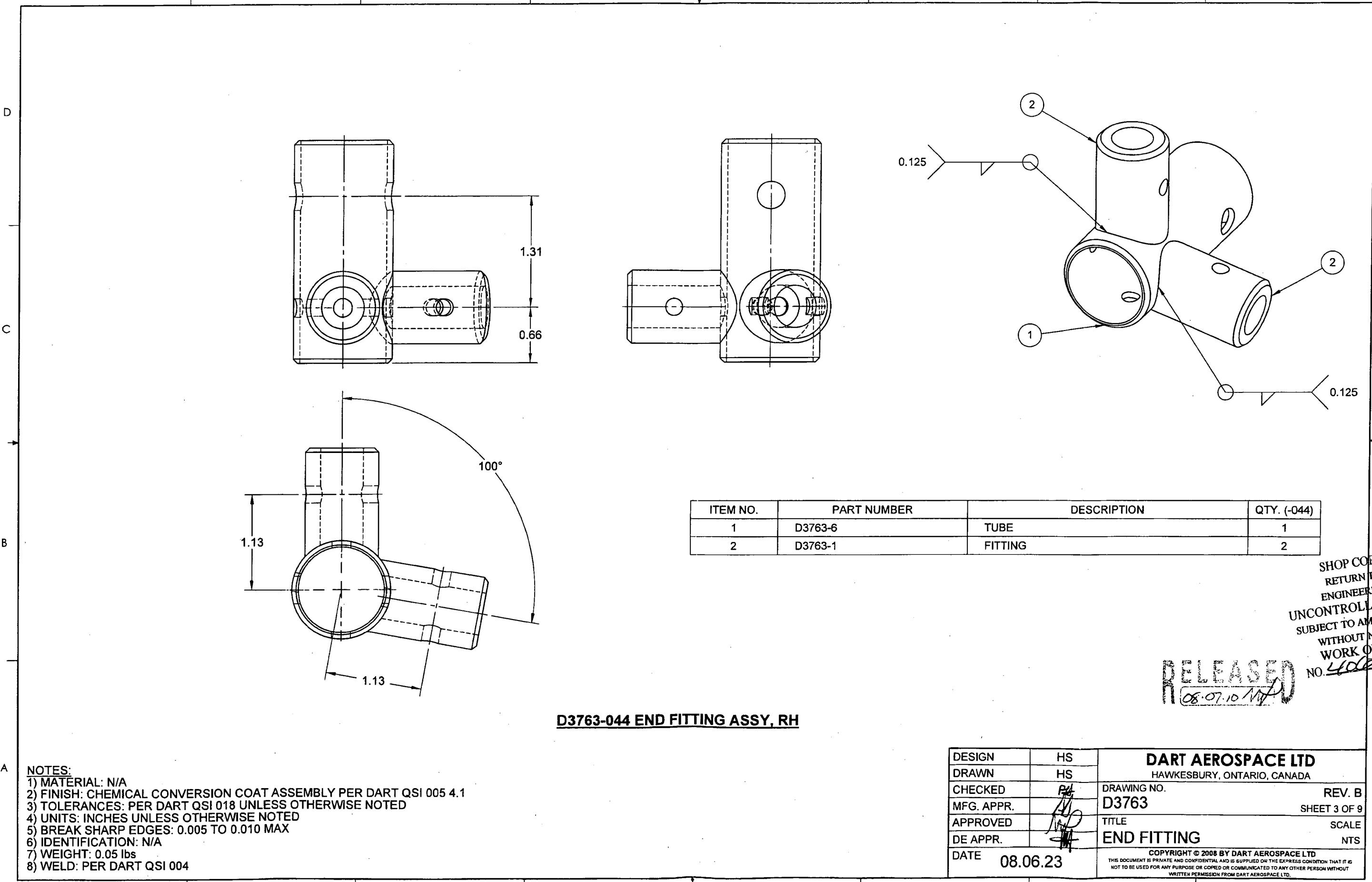
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs
- 8) WELD: PER DART QSI 004

B	CHANGE HOLES SIZE, ADD -7 PART AND -045 ASSY	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION		
DESIGN	HS	<b>DART AEROSPACE LTD</b>	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3763	SHEET 1 OF 9
APPROVED		TITLE	SCALE
DE APPR.		END FITTING	NTS
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8 7 6 5 4 3 2 1

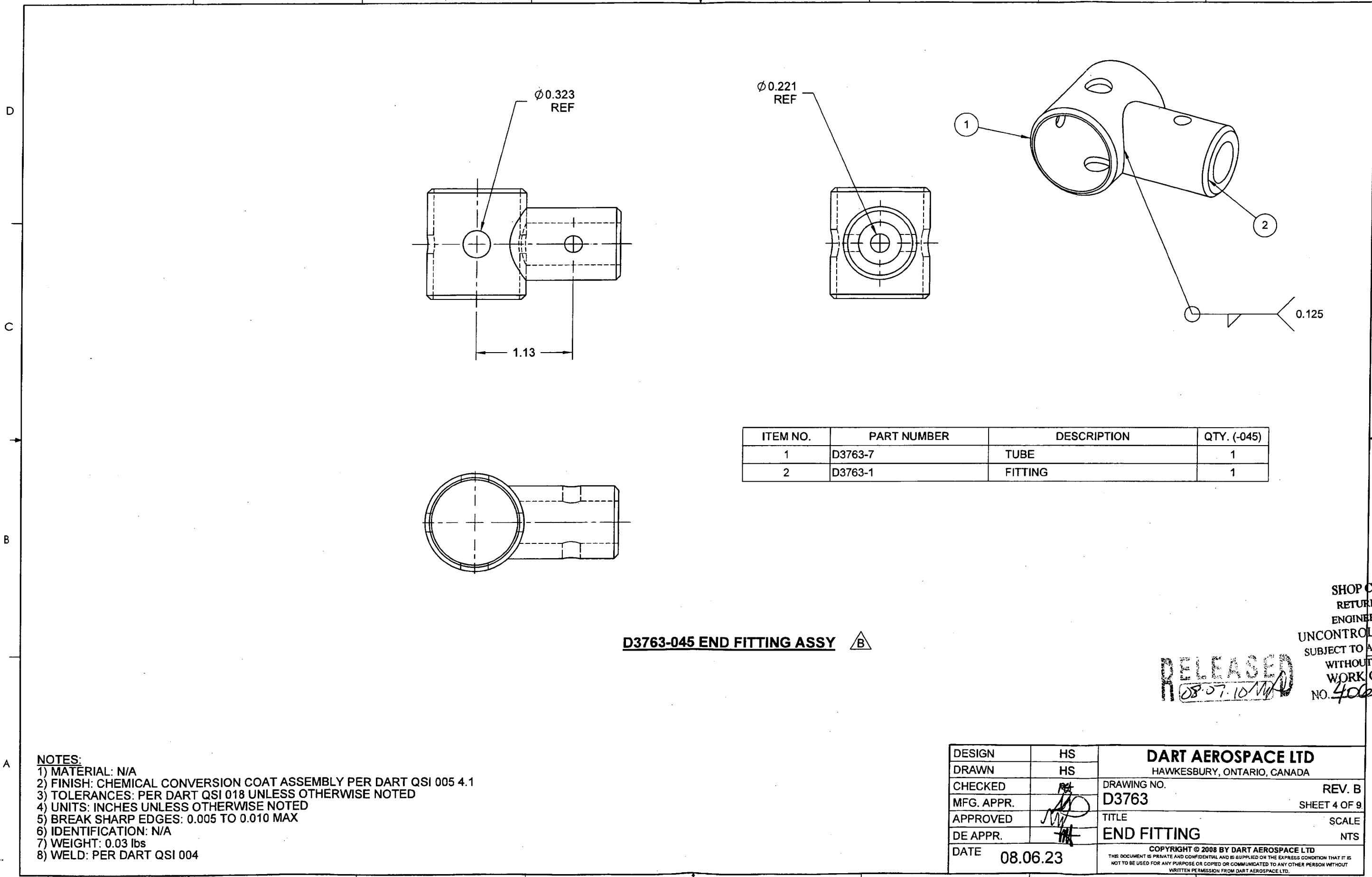


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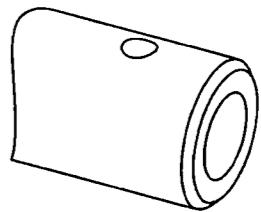
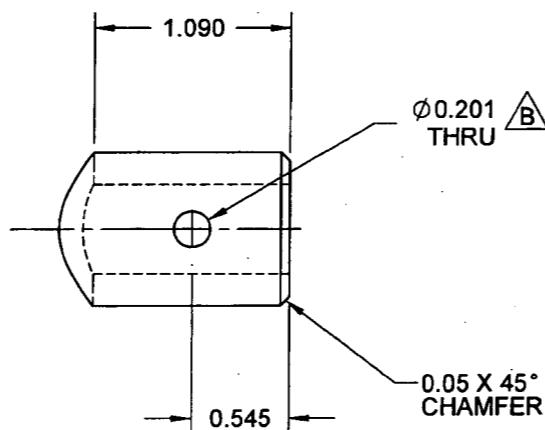
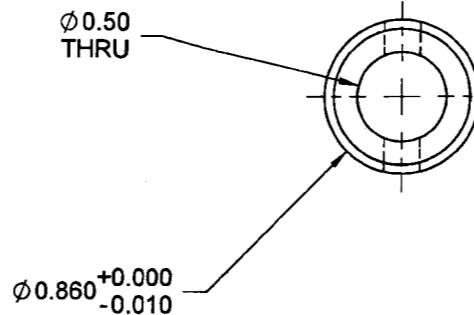
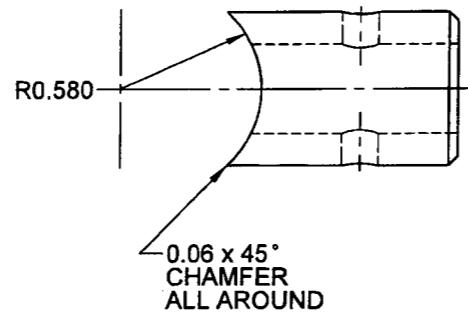


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8 7 6 5 4 3 2 1

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NO. 40685

D3763-1 FITTING

RELEASED  
08-07-10 TPD

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A

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PM</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>PM</i>	D3763	SHEET 5 OF 9
APPROVED	<i>PM</i>	TITLE	SCALE
DE APPR.	<i>PM</i>	END FITTING	NTS
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8 7 6 5 4 3 2 1

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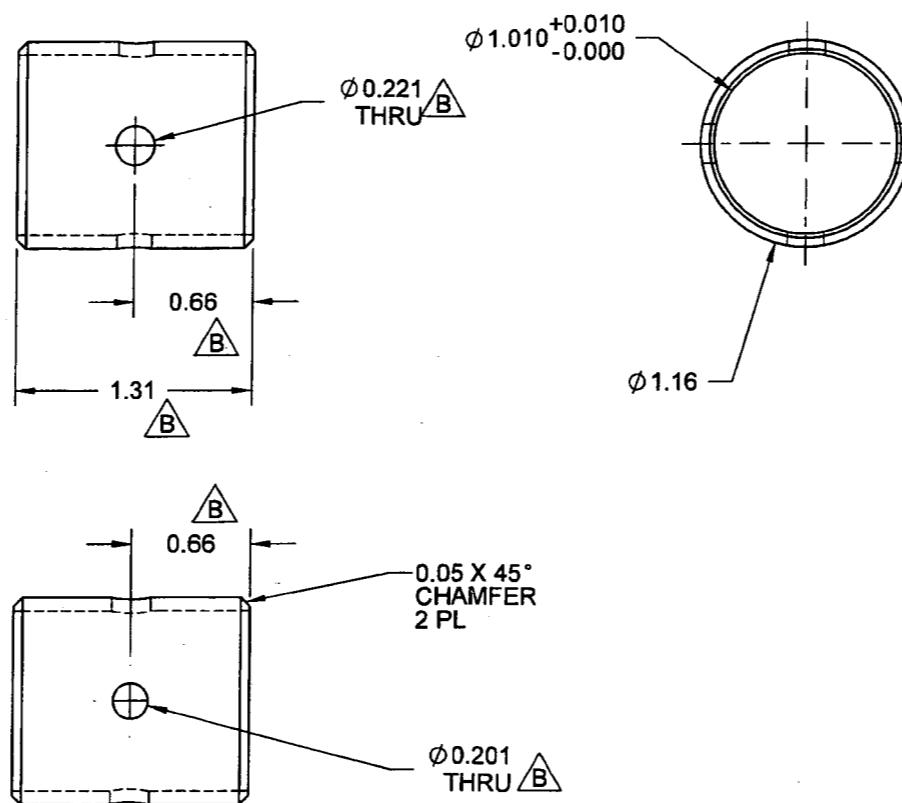
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D3763-3 TUBE

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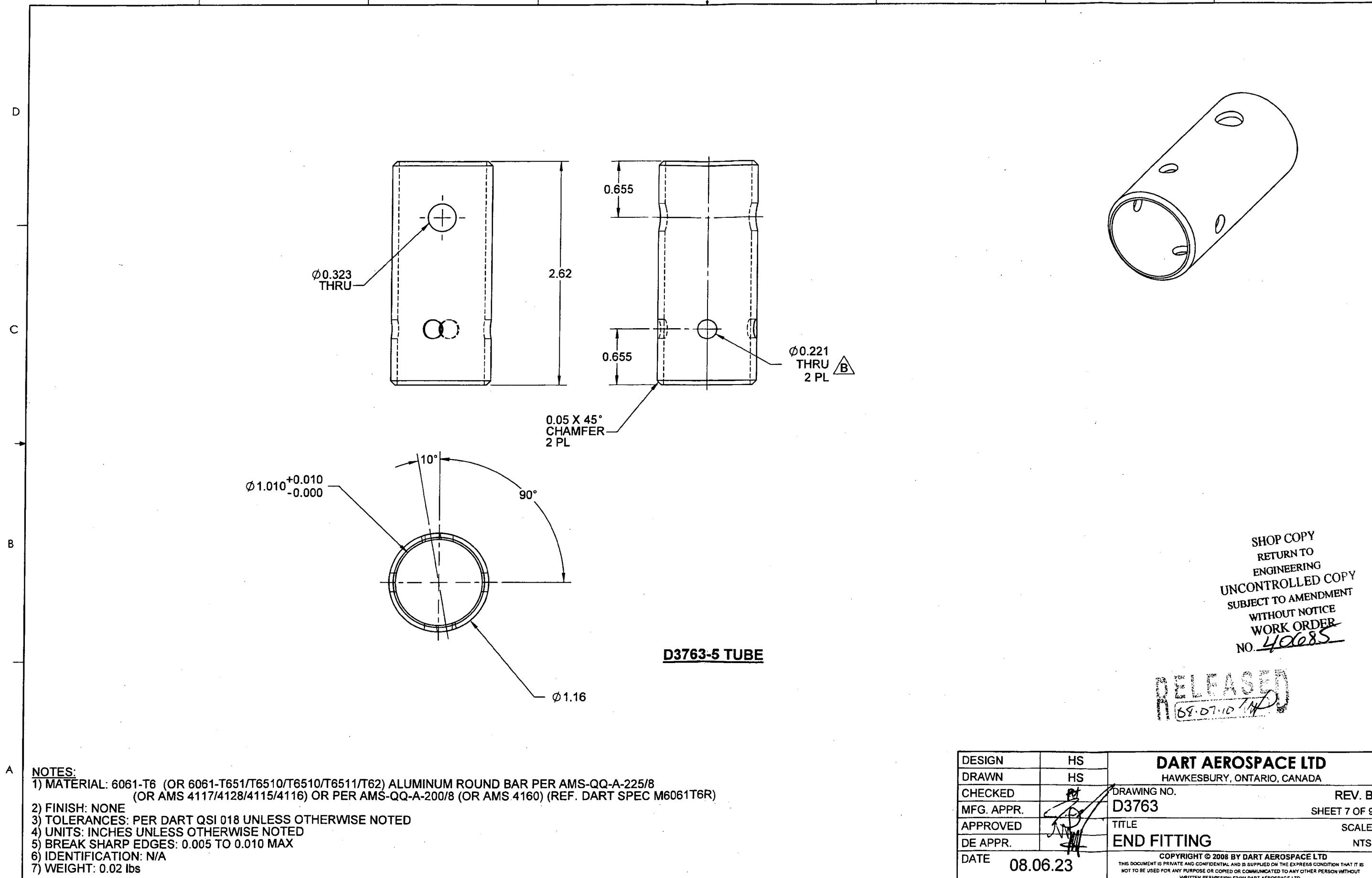
RELEASED  
08.07.10 JKD

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

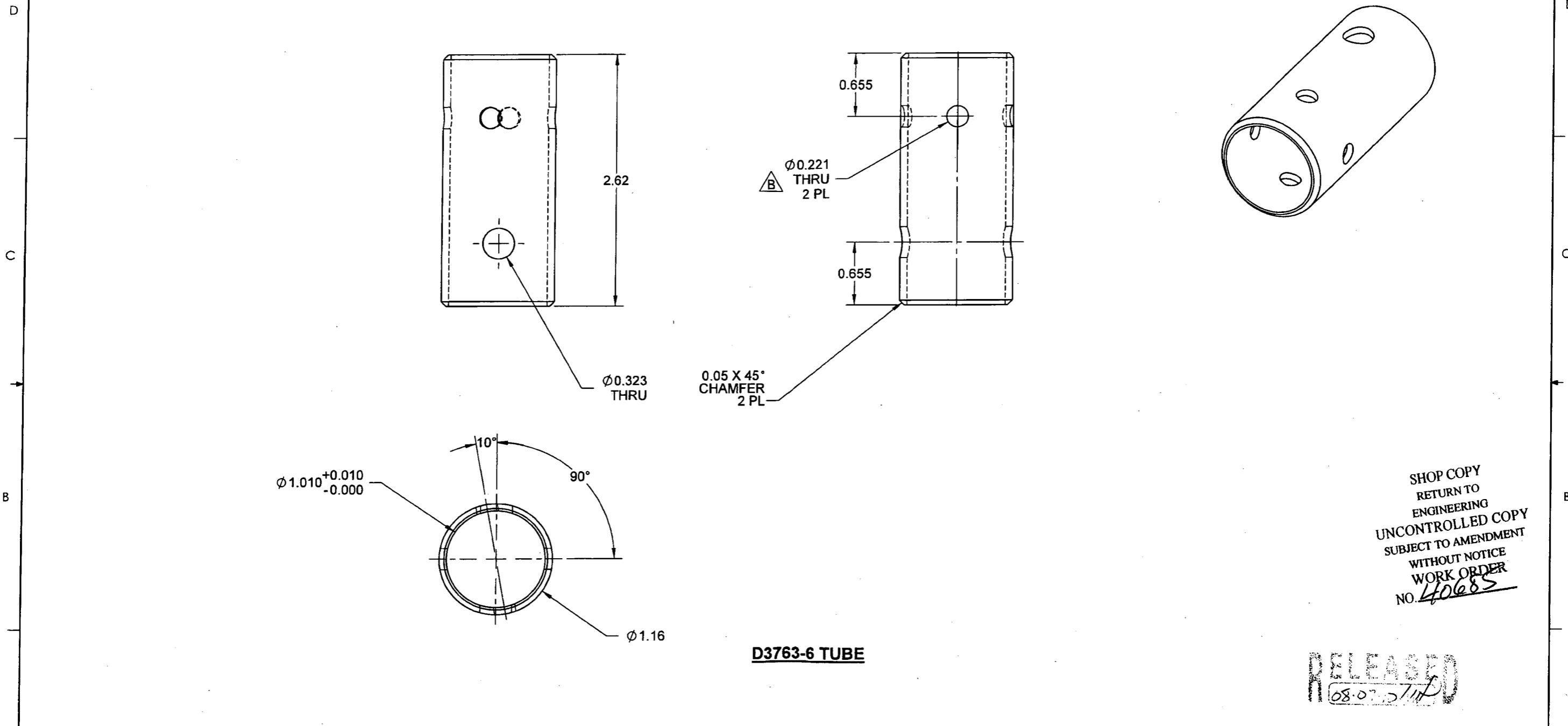
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DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>PT</u>	DRAWING NO.	REV. B
MFG. APPR.	<u>PT</u>	D3763	SHEET 6 OF 9
APPROVED	<u>PT</u>	TITLE	SCALE
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



**NOTES:**  
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 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 0.02 lbs

DESIGN	HS	<b>DART AEROSPACE LTD</b>
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA
CHECKED	SI	DRAWING NO.
MFG. APPR.	SI	<b>D3763</b>
APPROVED	SI	REV. B
DE APPR.	SI	SHEET 8 OF 9
DATE	08.06.23	TITLE
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		SCALE
		NTS

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08.07.2023

8 7 6 5 4 3 2 1

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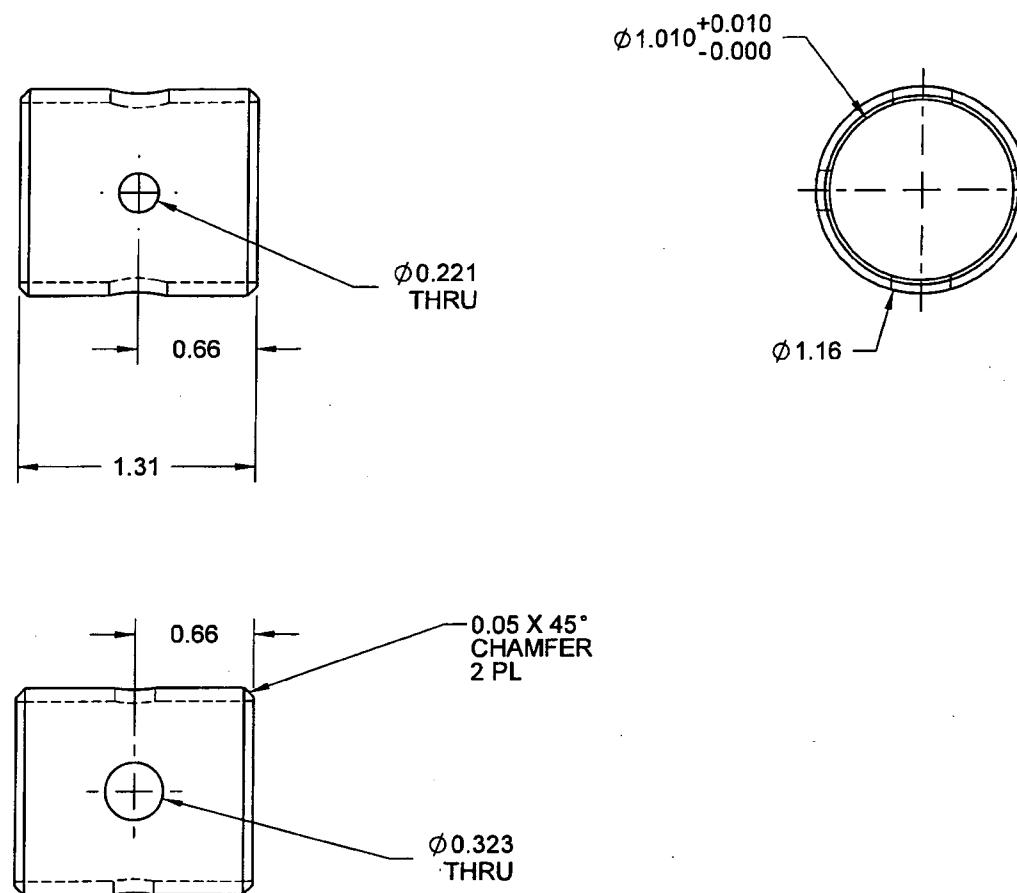
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NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RS	DRAWING NO.	
MFG. APPR.	✓	D3763	REV. B
APPROVED	✓	TITLE	
DE APPR.	✓	END FITTING	SCALE NTS
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